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1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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D206-642-541
Job Sheet 200927



Part No: D206-642-541

Job Qty: 1 pcs

Part Name: Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/19/19

Job Tracking No:

Due Date: 10/18/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG D3274-041 REV G IPP Rev:F 08-06-02 add comment DD verified by:EC IPP Rev:G 08-10-09 revise details DD verified by:EC IPP REV:H 13.09.05 CHG004/ ECN13-634 DD VERF:JLM IPP REV:I 14.04.28 AS PER ECN14-520 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier	Sign-off
					Setup Run Hrs Hrs	Workcenter / Supplier Lead Time	
110	Skidtubes - 1	1 pcs	10/18/19		0.00 2.17	Skidtubes - 1	TE BE
						Skidtubes - 2	
						Skidtubes - 3	
						Skidtubes - 4	
						Skidtubes - 5	
						Skidtubes - 6	
						Skidtubes - 7	
114	QC 5	1 pcs	10/18/19		0.00 0.00	QC 5 - 10	OCT 09 2019 DAS 68 9-89
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
116	QC 10	1 pcs	10/18/19		0.00 0.00	QC 10 - 10	OCT 09 2019 DAS 68 9-89
						QC 10 - 18	
						QC 10 - 24	
						QC 10 - 43	



Container No: S218334



Part: D206-642-541

Job No: 200927

Serial No/Batch: S218334

Revision: G

Inspector:

Exp Date:

Instructions: FAA STC SA00475SE 18/10/17, TAA STC SH98

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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

120 Handfinish - 1-1 Chemical-B4B	1 pcs	10/18/19	0.00 0.68	QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	OCT 11 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
130 QC 7	1 pcs	10/18/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	BE TF
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	

					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
150 Skidtubes - 2 - B4B	1	10/18/19	0.00 2.08	Skidtubes - 1 - B4B		
pcs			44min TF	Skidtubes - 2 - B4B		
			32min TF	Skidtubes - 3 - B4B		
				Skidtubes - 4 - B4B		TF
				Skidtubes - 5 - B4B		
				Skidtubes - 6 - B4B		
				Skidtubes - 7 - B4B		
160 QC 5	1	10/18/19	0.00 0.00	QC 5 - 10		
pcs				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		BE MLC
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
				QC 5 - 61		
				QC 5 - 81		
170 Skidtubes - 3 - B4B	1	10/18/19	0.00 2.17	Skidtubes - 1 - B4B		
pcs				Skidtubes - 2 - B4B		
				Skidtubes - 3 - B4B	MLC	MLC
				Skidtubes - 4 - B4B		
				Skidtubes - 5 - B4B		
				Skidtubes - 6 - B4B		
				Skidtubes - 7 - B4B		
180 QC 5	1	10/18/19	0.00 0.00	QC 5 - 10		
pcs				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		BE
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		

					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
190 Skidtubes - 4 - B4B	1 pcs	10/18/19	0.00 2.75	101-11-11	Skidtubes - 1 - B4B	
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	TF
				24230	Skidtubes - 5 - B4B	BE
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
200 QC 5	1 pcs	10/18/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	OCT 31 2019
					QC 5 - 9	DAS 68 9-89
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
210 QC 10	1 pcs	10/18/19	0.00 0.00		QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	
					QC 10 - 50	
					QC 10 - 58	
					QC 10 - 9	
220 Handfinish - 2-1 Pressure-B4B	1 pcs	10/18/19	0.00 0.45		Handfinish - 2 - 1 - B4B	
					Handfinish - 2 - 2 - B4B	NOV 04 2019
					Handfinish - 2 - 3 - B4B	
					Handfinish - 2 - 4 - B4B	
230 Spray Paint - 2 - B4B	1 pcs	10/18/19	0.00 0.40		Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	RD 19-11-5
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
240 QC 14	1 pcs	10/18/19	0.00 0.00		QC 14 - 15	RD 19-11-06
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	

						QC 14 - 9	
						QC 14 - 68	
						QC 14 - 40	
						QC 14 - 19	
						QC 14 - 43	
						QC 14 - 24	
						QC 14 - 61	
						QC 14 - 81	
244 Handfinish - 3-1- WingWalk- B4B	1 pcs	10/18/19	0.00	0.50		Handfinish - 3 - 1 - B4B	ll 14-11-06
						Handfinish - 3 - 2 - B4B	
						Handfinish - 3 - 3 - B4B	
						Handfinish - 3 - 4 - B4B	
						Handfinish - 3 - 5 - B4B	
246 QC 3	1 pcs	10/18/19	0.00	0.00		QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	BF 19-11-06
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
250 Handfinish - 4-1-Assembly- B4B	1 pcs	10/18/19	0.00	0.45		Handfinish - 4 - 1 - B4B	ll 14-11-06
						Handfinish - 4 - 10 - B4B	
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	
						Handfinish - 4 - 5 -	

					B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
260 QC 5	1 pcs	10/18/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
270 Handfinish - 4-2-Assembly-B4B	1 pcs	10/18/19	0.00	0.68	Handfinish - 4 - 1 - B4B	
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
280 QC 5	1 pcs	10/18/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	

DAS
81
9-89

NOV 06 2019

11-14-06

					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	DAS
					QC 5 - 68	NOV 06 2019 68
					QC 5 - 9	9-89
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
290 Packaging 3-1 - Stock - B4B	1	10/18/19	0.00 0.00		Packaging 3 - 1 - B4B	
pcs					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	mc 7/11/19
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
295 DC - 1 - B4B	1	10/18/19	0.00 0.00		DC - 1 - B4B	NOV 07 2019
pcs					DC - 2 - B4B	
300 QC 21 - FG	1	10/18/19	0.00 0.00		QC 21 - FG - 21	NOV 07 2019
pcs					QC 21 - FG - 70	
					QC 21 - FG - 53	

Part Op 110 - (Skidtubes) ****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE**** 1- remove fwd indexing ridge as per Descriptions: dwg D3274. Prepare for welding 2- weld fwd cap as per dwg D3274 and QSI004 AR Aluminum Rod Batch: 138989 / 139011 3- grind fwd cap weld on top surface only 4- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end. 5-Drill Aft cap pilot hole using DT8025 6 -Cleco DT8025 in position and install pilot hole drill Jlg DT8742A,B,C,D and DT8742. Drill 3/16" pilot holes as per Dwg D3274 7 -Remove inner indexing ridge on aft end of

skidtube as per Dwg D3274 scribe batch # 8 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

114 - (QC5- Inspect part completeness to step on W/O)

116 - (QC10- Inspect visual per QSI004- ground welds)

120 - (Chemical Conversion Coat per QSI005 4.1)

130 - (QC7-Inspect Chemical Conversion Coat)

150 - (Skidtube) 1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274 2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube 3-Bond web in place as per Dwg D3274 & QSI 015. (Adhere for 12 hours)

160 - (QC5- Inspect part completeness to step on W/O)

170 - (Skidtube) 1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position. 2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297" . Deburr 3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES 4- Countersink crossbolt spacer holes as per Dwg D3274 5- prepare for welding

180 - (QC5- Inspect part completeness to step on W/O)

190 - (Skidtube) 1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod 3-Grind cross bolt welds flush as per Dwg D3274.

****INSPECT FOR PIN HOLES IN WELD**** 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

200 - (QC5- Inspect part completeness to step on W/O)

210 - (QC10- Inspect visual per QSI004- ground welds)

220 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

230 - (Spray Paint / NDT Room) Make sure Nut Plate Thread is protected using paint screw. 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5 200299 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5 213125

240 - (QC14- Inspect Spray Paint)

244 - (Wing Walk as per dwg QSI005 4.4 Batch 5309 367)

246 - (QC3- Inspect Part Finish)

250 - (Assemble as per dwg) 1-Install Nut Plate as per Dwg D3274. Apply LPS-PROCYON to Nut Plate and rivets.

260 - (QC5- Inspect part completeness to step on W/O) Inspect Nut Plate & Inserts

270 - (Assemble as per dwg) 1-Install wearpads as per Dwg D3274. 2-Install ring as per Dwg D3274 3-Inspect for foreign objects as per QSI 024 4-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

280 - (QC5- Inspect part completeness to step on W/O)

290 - (Identify as per dwg & Stock Location: _____) Location : FG073

295 - (Document Control) Photocopy bluefile & type labels per PPP D206-642- 541 CHG005

300 - (QC21- Final Inspection - Work Order Release) 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 using DT10280 and deburr.

Job BOM

Part / Item	Component Name	Quantity	Operation
D3274-041BENT	Skidtube Assembly 206	1 pcs (1 ea)	110-Skidtubes - 1
D3285-1	Cap	1 pcs (1 ea)	110-Skidtubes - 1
D3282-041	Float Web (206L/407)	1 pcs (1 ea)	150-Skidtubes - 2 - B4B
D2649	Cross Bolt Spacer	12 pcs (12 ea)	190-Skidtubes - 4 - B4B
D3275-1	Cross Bolt Spacer	14 ¹² pcs (12 ea)	190-Skidtubes - 4 - B4B
ALS4-1032-130	Rivnut	78 Ea (78 ea)	250-Handfinish - 4-1-Assembly-B4B
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B
D3415-041	Nut Plate	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B
AN3C4A	Bolt	80 Ea (80 ea)	270-Handfinish - 4-2-Assembly-B4B
AN4C5A	Bolt	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B
D2646	Aft Cap	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B
D3413-1	O-Ring	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B
D3537-1	Wearpad	9 pcs (9 ea)	270-Handfinish - 4-2-Assembly-B4B
D3537-3	Wearpad	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B
D3672-1	Washer, Phenolic	2 pcs (2 ea)	270-Handfinish - 4-2-Assembly-B4B
D4956-15	Wearplate Fwd	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B
D4956-23	Wearplate Center Fwd	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B
D4956-35	Wearplate Aft	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B
D4956-39	Wearplate Center Aft	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B
NAS1149C0332R	Washer (AN960C10L)	80 Ea (80 ea)	270-Handfinish - 4-2-Assembly-B4B
NAS1149C0463R	Washer (AN960C416)	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B

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Container

5189763

5043738

5219825

5225932

5199330

5057267

5099573

5163230-?

5218880

5229822

5057446

5197616

1-165896

8225791

5218982

F164008

5200829

2210726

5209985

5201002

5218161

8104372

012786

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D3274-041BENT	1	5	0
	D3285-1	1	7	0
150-Skidtubes - 2 - B4B	D3282-041	1	3	0
190-Skidtubes - 4 - B4B	D2649	12	83	0
	D3275-1	12	196	0
250-Handfinish - 4-1-Assembly-B4B	ALS4-1032-130	78	5,946	0
	CCR264SS3-3	2	55	0
	CR3212-4-03	2	38	0
	D3415-041	1	1	0
270-Handfinish - 4-2-Assembly-B4B	AN3C4A	80	584	0
	AN4C5A	1	70	0
	D2646	1	58	0
	D3413-1	1	19	0
	D3537-1	9	144	0
	D3537-3	1	10	0
	D3672-1	2	1,439	0
	D4956-15	1	7	0
	D4956-23	1	16	0
	D4956-35	1	21	0
	D4956-39	1	9	0
	NAS1149C0332R	80	2,920	0
	NAS1149C0463R	1	205	0
Part Specifications				
Specifications could not be found.				

Plex 9/19/19 10:45 AM Dart.lajeunesse.marie

Qty	Qty	Part Number	Description
1	1	D3274-041	SKIDTUBE ASSEMBLY
1	1	D3274-043	SKIDTUBE ASSEMBLY
1	1	D3274-045	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-046	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-047	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-048	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-049	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-050	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-051	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-052	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-053	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-054	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-055	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-056	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-057	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-058	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-059	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-060	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-061	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-062	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-063	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-064	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-065	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-066	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-067	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-068	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-069	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-070	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-071	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-072	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-073	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-074	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-075	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-076	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-077	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-078	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-079	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-080	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-081	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-082	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-083	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-084	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-085	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-086	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-087	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-088	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-089	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-090	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-091	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-092	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-093	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-094	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-095	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-096	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-097	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-098	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-099	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-100	SKIDTUBE ASSEMBLY (FOR PH)

GENERAL NOTES:

1. MATERIAL: N/A

2. FINISH: N/A

3. ON-045: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

4. ON-046: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

5. ON-047: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

6. ON-048: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

7. ON-049: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

8. ON-050: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

9. ON-051: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

10. ON-052: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

11. ON-053: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

12. ON-054: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

13. ON-055: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

14. ON-056: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

15. ON-057: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

16. ON-058: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

17. ON-059: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

18. ON-060: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

19. ON-061: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

20. ON-062: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

21. ON-063: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

22. ON-064: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

23. ON-065: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

24. ON-066: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

25. ON-067: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

26. ON-068: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

27. ON-069: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

28. ON-070: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

29. ON-071: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

30. ON-072: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

31. ON-073: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

32. ON-074: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

33. ON-075: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

34. ON-076: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

35. ON-077: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

36. ON-078: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

37. ON-079: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

38. ON-080: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

39. ON-081: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

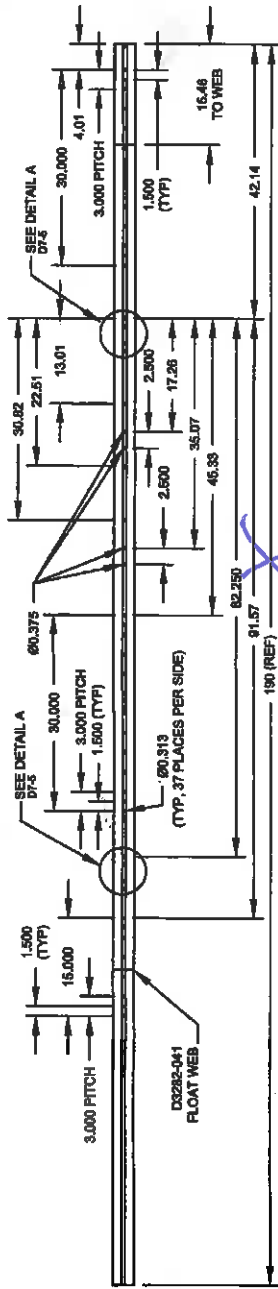
40. ON-082: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3274-041 WEB

RELEASED
R 2016-07-26
EQU 11-116

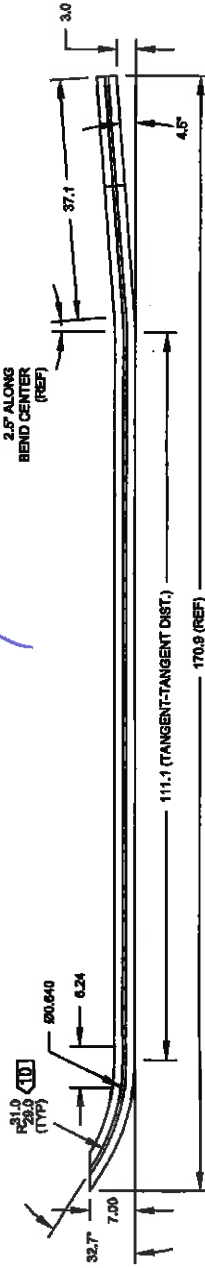
REV.	DESCRIPTION	DATE
G	ADD -045 CONFIGURATION (FOR PH) ZN AS-4, AS-6	16.04.25
F	REVISE NOTE 2: ADD ANTI-SKID PAINT, REMOVE GASKETS PER IN-0208-043 REV Q	14.04.15
E	REVISE NOTE 2: FINISH NOW PRIME/PAINT WAS POWDERCOAT, REF. PAR 13-256	13.06.17
D	NEW INSERTS, SS WEARSHOE + GASKET	08.12.19
C	ADD -043; NEW INSERTS	05.08.16
B	MOVE SADDLE HOLE; 42-14 WAS 42.78	04.08.09
A	NEW ISSUE	04.03.15
REV.	DESCRIPTION	DATE
DESIGN	CP	BY
DRAWN	RF	
CHECKED	AK	
MFG. APPR.	JLM	
DE APPR.	DS	
DATE	16.04.25	

DART AEROSPACE USA, INC	BUGENE, OR
DRAWING NO.	D3274
TITLE	SKIDTUBE ASSEMBLY
SCALE	1 OF 6
REV.	G
SHEET	1 OF 6
DATE	16.04.25

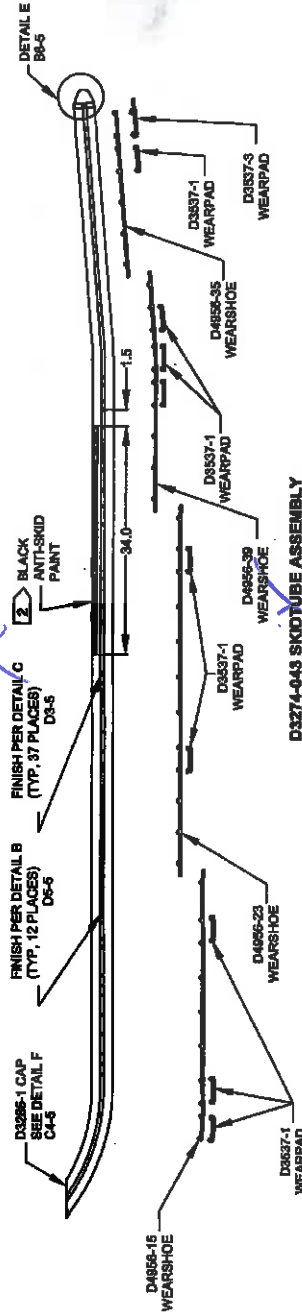
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DS274-043 DRILLING/ASSEMBLY DETAIL



DS274-043 BEND/DRILLING DETAIL



DS274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

DESIGN	CP	RF	AK	JLM	DS	DATE	16.04.25
DRAWN							
CHECKED							
INFG. APPR.							
APPROVED							
DE APPR.							
DATE							

DART AEROSPACE USA, INC
EUGENE, OR

DRAWING NO. DS274

REV. G

SHEET 3 OF 8

TITLE SKIDTUBE ASSEMBLY

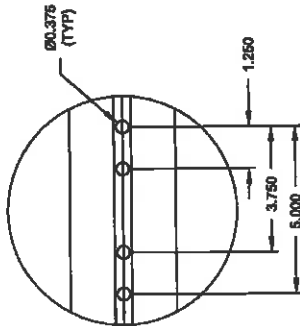
SCALE NTS

DATE 16.04.25

COMPONENT IS 3884 BY DART AEROSPACE USA, INC.
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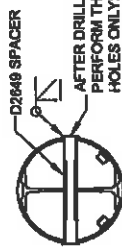
RELEASED
N 2016-07-26

DETAIL A: DRILL DETAIL
D42, D43, D43, D43



DETAIL B
B42, B43

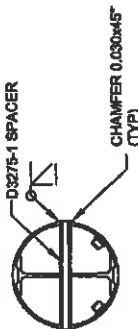
FOR Ø0.375 HOLES ONLY



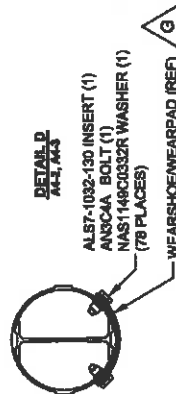
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. CSORE TO Ø0.31350.75 DEEP

DETAIL C
B42, B43

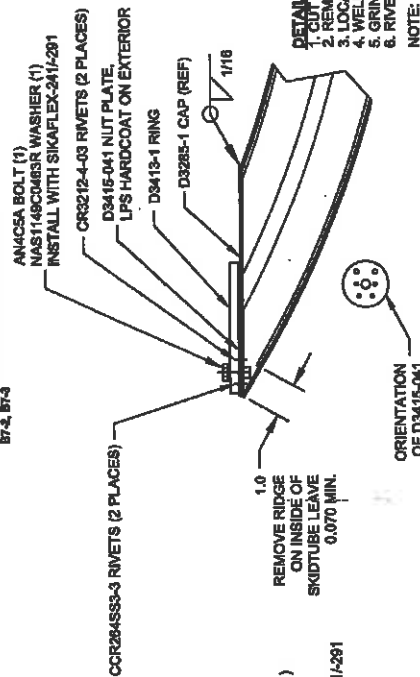
FOR Ø0.313 HOLES ONLY



DETAIL D
A42, A43

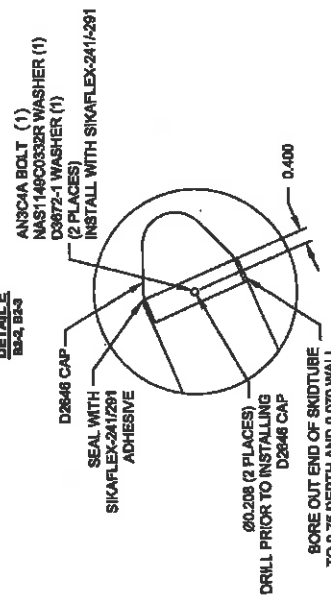


DETAIL F: END FINISHING DETAIL
B7-3, B7-4



DETAIL F NOTES
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE
NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

DETAIL E
B42, B43



DESIGN	CP	REV. G
DRAWN	RF	EUGENE, OR
CHECKED	AK	DRAWING NO. D3274
MFG. APPR.	JLM	SHEET 5 OF 8
APPROVED	DJ	TITLE SKIDTUBE ASSEMBLY
DE APPR.		SCALE NTS
DATE	16.04.25	

RELEASED
R 2016-07-26

-041/-043 DETAILS

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐ ☐ ☐
Scrap ☐ ☐ ☐
Use-as-is ☐ ☐ ☐

DEPARTMENT/PROCESS

Skid-tube ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐
Machining ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐
Large Fab ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐
Small Fab ☐ ☐ ☐ Finishing ☐ ☐ ☐

Engineering ☐ ☐ ☐
Water Jet ☐ ☐ ☐
Supplier ☐ ☐ ☐
Quality ☐ ☐ ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Manufacturing Process ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Equip/Tooling ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Handling/Preservation ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Material ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Product Improvement ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Process Improvement ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Human Factors ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
☐	☐	☐	☐
Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐
Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐
Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐
Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐
Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐	

Other/Details: _____